

DS

Date: Thursday, 19/03/2009 11:07:19 AM  
User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : HELI-ACCESS STEP LH (FOLDING)
<b>Job Number</b> : 46599	
<b>Estimate Number</b> : 12567	
<b>P.O. Number</b> :	<b>Part Number</b> : D412630033
<b>This Issue</b> : 19/03/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : IIN D412-630
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : M
<b>Previous Run</b> : 46548	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 03/04/2009 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUL 09 03 19</u>	
<b>Comment</b> : Est. Rev:A New Issue 06-11-08 JLM est rev B ecn 1019, added d2807-041 EC verified by:DD Est Rev:C 09-03-02 as per rev.m DD verified by:ec	

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL

**Comment:** DOCUMENT CONTROL

Photocopy bluefile &amp; create labels per PPP D412-630-033 CHG003

S 09/04/17

2.0

D2012107

Clevis



(46)

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Clevis

Pick:

Qty Part Number

Description

Batch

1

D2012-107

Clevis

M45074

9/3/31

SC

3.0

D2803041

Bracket Assembly

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bracket Assembly

Pick:

Qty Part Number

Description

Batch

1

D2803-041

Bracket Assembly LH

46763

CB

4.0

D2804041

Bracket Assembly



(46)

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bracket Assembly

Pick:

Qty Part Number

Description

Batch

1

D2804-041

Bracket Assembly LH

46331

9/4/11

SC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 46599

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2807041

Door prop



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Support Prop

Batch: 1344858

SP

6.0

D2813

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Pick:

Qty Part Number

Description

Batch

2 D2813

Washer

1346332

SP

7.0

D3562041

Step Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Step Weldment LH

Pick:

Qty Part Number

Description

Batch

1 D3562-041

Step Weldment LH

0346551

EP509/04/03

8.0

D33951

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bushing

Pick:

Qty Part Number

Description

Batch

4 D3395-1

Bushing

1346345

SP

9.0

AN3C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

Pick:

Qty Part Number

Description

Batch

2 AN3C21A

Bolt

1109148

9/3/31

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 46599

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN8C16

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

2

AN8C16

Bolt

M105969

SP

11.0

AN310C8

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

Pick:

Qty

Part Number

Description

Batch

2

AN310C8

Nut

M109148

SP

12.0

MS24665302

Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Cotter Pin

Pick:

Qty

Part Number

Description

Batch

2

MS24665-302

Cotter Pin (or AN380C3-4)

M106763

SP

13.0

NAS1515H3

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

6

NAS1515H3

Washer

M109268

SL

14.0

NAS1515H5L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

WASHER

Pick:

Qty

Part Number

Description

Batch

4

NAS1515H5L

Washer

M108964

9/3/31

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 46599

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description:

15.0

NAS1515H8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

M111275

SP

16.0

MS210433

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
4	MS21043-3	Nut

Batch

M110560

SP

17.0

MS24693C280

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description
2	MS24693-C280	Screw (or MS24694-C565)

Batch

M111279

9/13/31

SP

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: M109929

COAT exposed HARDWARE WITH LPS PROCYON.

A/R LPS PROCYON

BATCH:

M104251

8/509/04/23 (4)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/09/04/15 (24 CM)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 46599

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Pick Packing Kit

21.0

D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)  
Bushing

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2806-1	Bushing	42174

SS 09/04/14 (x4)

22.0

D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)  
Bushing

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2806-3	Bushing	B42175

SS 09/04/14 (x4)

23.0

D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)  
Strut

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	D2810-5	Strut	B44552 x1

SS 09/04/14 (x4)

24.0

D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)  
Spacer

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D3396-1	Spacer	B41670

SS 09/04/14 (x4)

25.0

AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)  
Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
			M1091147

SS 09/04/14 (x4)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 19/03/2009 11:07:20 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 46599

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 AN4C6A Bolt

26.0

AN4C10A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN4C10A

Bolt

M106302

SS 09/04/14 (x4)

27.0

AN4C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN4C15A

Bolt

M107082

SS 09/04/14 (x4)

28.0

AN44C7A

Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN44-C7A

Eyebolt

M100446

SS 09/04/14 (x4)

29.0

AN5C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN5C15A

Bolt

M109148

SS 09/04/14 (x4)

30.0

NAS1515H4

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 28.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

Description

Batch

7 NAS1515H4

Washer

M109267

SS 09/04/14 (x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 19/03/2009 11:07:20 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 46599

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

NAS1515H5

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total: 28.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

Description

Batch

7 NAS1515H5

Washer

M109430

SS 09/04/14 (K4)

32.0

MS210434

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description

Batch

4 MS21043-4

Nut

M111177

SS 09/04/14 (K4)

33.0

MS210435

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description

Batch

3 MS21043-5

Nut

M109053

SS 09/04/14 (K4)

34.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

SS 09/04/17 (K4)

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-033

Location: A

PPP Rev: A

9/4/17

SS

36.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SS 09/04/20 (K4)

Job Completion



MF 09-04-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

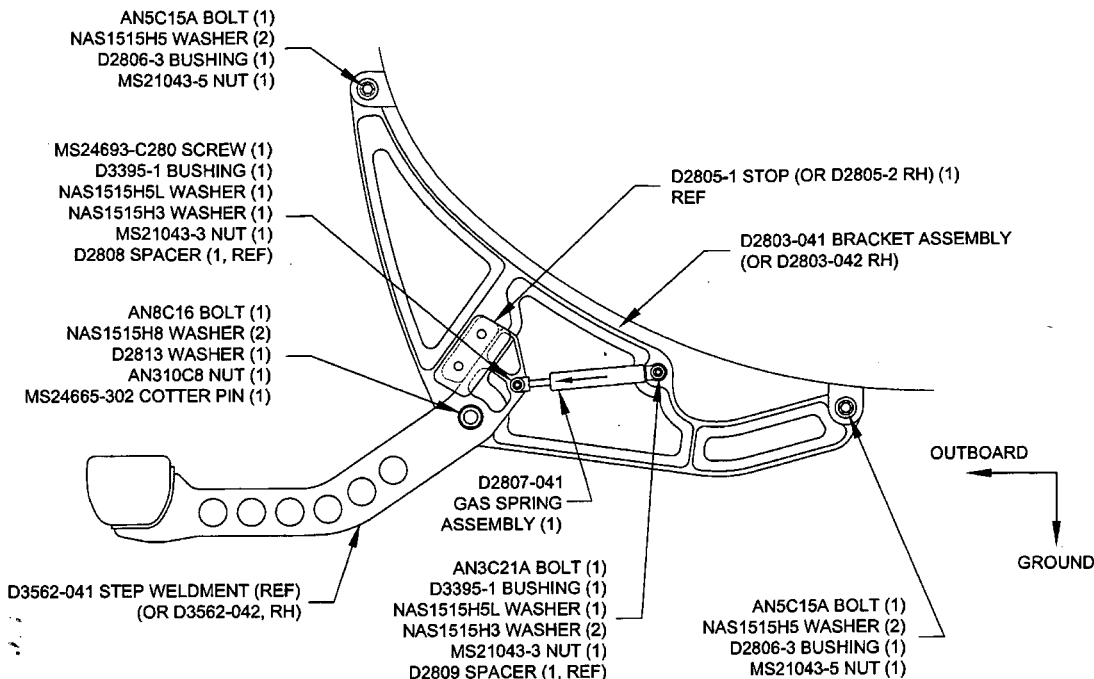
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

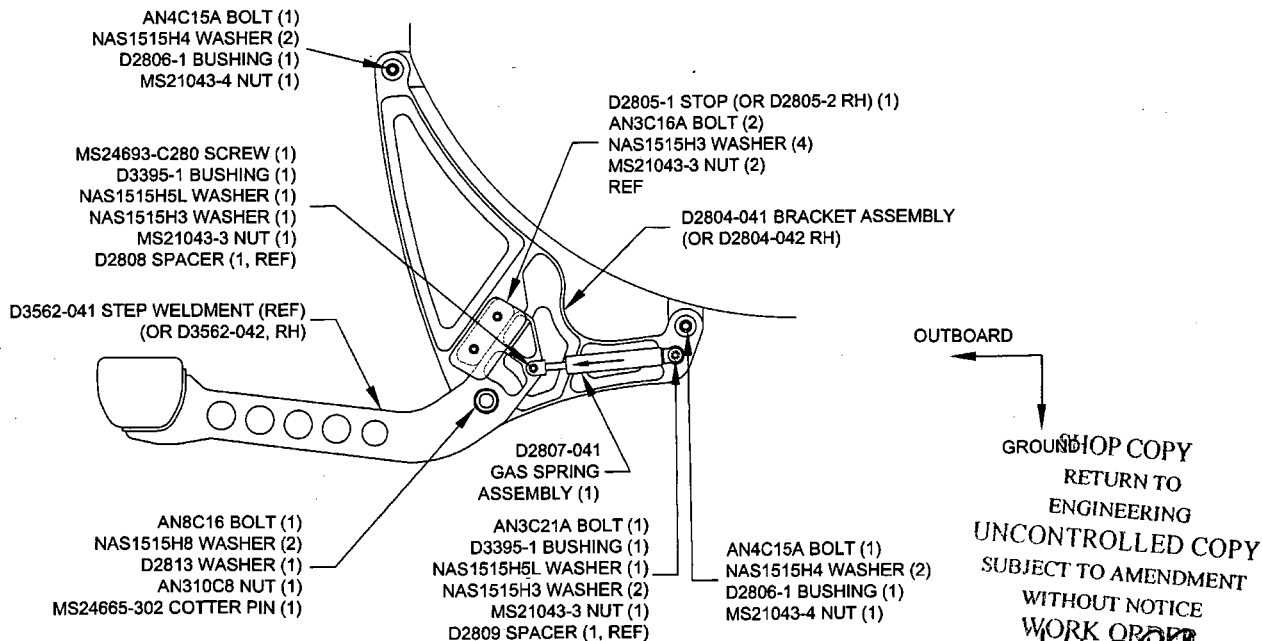
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**D412-630-033/-034 Heli-Access-Step™ Installation**



**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation  
(View rotated 90° CW)**



**FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation  
(View rotated 90° CW)**

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Revision: **M**  
Date: 08.12.12

Date: Monday, 23/03/2009 12:52:13 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	HELI-ACCESS STEP LH (FOLDING)
<b>Job Number</b> :	46599		
<b>Estimate Number</b> :	12567		
<b>P.O. Number</b> :		<b>Part Number</b> :	D412630033
<b>This Issue</b> :	23/03/2009	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	IIN D412-630
<b>First Issue</b> :	19/03/2009	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	46548	<b>Drawing Revision</b> :	M
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :		<b>Due Date</b> :	03/04/2009
<b>Comment</b> :	Est. Rev:A New Issue 06-11-08 JLM est rev B ecn 1019, added d2807-041 EC verified by:DD Est Rev:C 09-03-02 as per rev.m DD verified by:ec		

**REFERENCE ONLY**

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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C 209104/14

**Comment:** DOCUMENT CONTROL

Photocopy bluefile &amp; create labels per PPP D412-630-033 CHG003

2.0	D2012107	Clevis
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Clevis

Pick:

Qty	Part Number	Description	Batch
1	D2012-107	Clevis	

3.0	D2803041	Bracket Assembly
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2803-041	Bracket Assembly LH	

Job Completion

